

Work Order ID 162771

162771

Page 1

Monday, June 12, 2017 12:44:33 PM

Item ID: D3947-4 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Panel , Lower RH Post (Sub-Component D350-766-015)
Start Date: 6/19/2017 Start Qty: 3.00 *3* Cust Item ID:
Required Date: 6/27/2017 Req'd Qty: 3.00 *3* Customer:
Reference: SCHEDULED/C

Approvals: Process Plan:  Date: JUN 12 2017 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3947	A

110

0.00

110

Purchasing

Purchasing

THERMOFORMING MACHINE

Memo

ISSUE P/O: 36858
SUPPLIER: PLASTECB

MANUFACTURE D3947-4 AS PER DWG

C OF C IS REQUIRED

34 JUN 28 2017 DAS 13 9-89

140

0.00

140

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

HAND FINISHING THERMOFORMING

Memo

3x SP 17-7-10 4

*145
SMALL FAB

TRIM TO DWG.

DAS 07 9-89
17/07/19

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Monday, June 12, 2017 12:44:33 PM

Page 2

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
240 240 26 70 27 98-2									
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : ☐							

Picklist Print

Monday, June 12, 2017 12:44:46 PM

Page 1

Work Order ID: 162771

162771

Parent Item: D3947-4

D3947-4

Parent Item Name: Panel , Lower RH Post (Sub-Component D350-766-015)

Start Date: 6/19/2017

Required Date: 6/27/2017

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP RevA: New issue DD verified by:EC
Add Step 105 Dry Material 10/04/21 DL
NOW OUTSIDE PROCESS DD VERF:DP

IPP RevB:
IPP REV:C 17.06.12

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3947-4P		Purchased	No				Each	0.0000		3			
----------	--	-----------	----	--	--	--	------	--------	--	---	--	--	--

D3947-4P

Panel , Lower RH Post (Sub-Component D350-766-015)

**

3x SP/7-7-10

DQA: _____ Date: _____



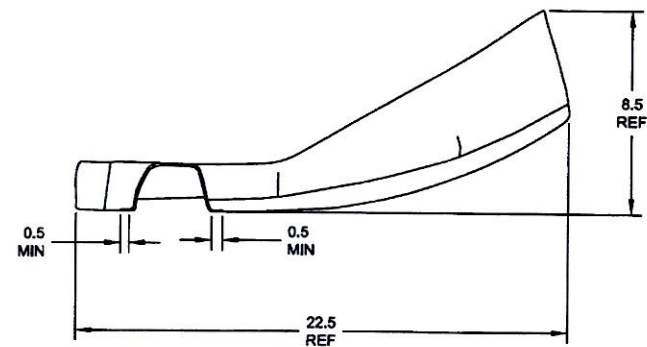
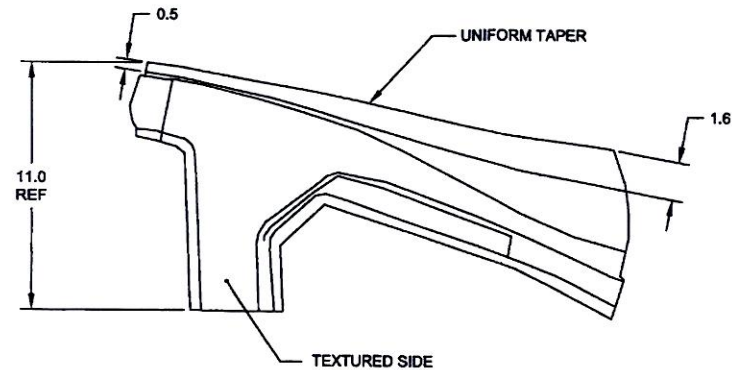
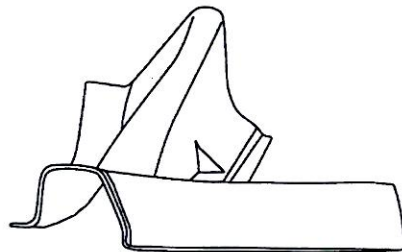
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : ☐							

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 16274
JUN 12 2017



D3947-4 PANEL, RH

RELEASED
09/05/20

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY58133 LIGHT GREY LEXAN SHEET 0.093 THICK
REF DART SPEC MLEXS.093-F6006-07
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3947-4" AND B/N USING VIBRATING STYLUS
- 7) WEIGHT: 0.62 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9484 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.065" ELSEWHERE

DESIGN	<i>PH</i>	DART AEROSPACE LTD	
DRAWN	<i>PH</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>PH</i>	D3947	SHEET 4 OF 4
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	PANEL (AS 350/355)	NTS
DATE	09.05.20	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO36858

Purchase Order Date 6/28/2017

PO Print Date 6/28/2017

Page Number 1 of 3

Order From :
PLAS-TECH
115 APPLEWOOD CRESCENT
CONCORD, ONTARIO L4K 5C1

VC-PLT01

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
JUN 28 2017

Contact Name	Buyer	Chantal Lavoie
Vendor Phone 416-736-0004	Customer POID	
	Customer Tax #	10127-2607
Ship To Contact	Terms	Net 60
Ship To Phone	Currency	CAD
Ship Via:	FOB	Destination-Collect
Ship Acct:		

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
----------	------------------------------	---------------------	-------------------	----	--------------------------	---------------	----------------

1	D3946-1P	Panel , Center Post (Sub-Com D350-766-015)	7/5/2017	FN	3.00	\$85.00	\$255.00
			Yes		Each		
			7/5/2017				

AS PER DWG D3946 REV. A
B162767

Line Total: \$255.00

2	D3947-4P	Panel , Lower RH Post (Sub-Component D350-766-015)	7/5/2017	FN	3.00	\$85.00	\$255.00
			Yes		Each		
			7/5/2017				

AS PER DWG D3947 REV. A
B162771

DAS
38
9-89

Line Total: \$255.00

SP17-710

Note:

6/28/2017

Ship Date: 07/06/2017

Pick Ticket - 23194

B DART AÉROSPACE LTD.
I 1270 ABERDEEN STREET
L HAWKESBURY ON K6A 1K7
L CA
T Attn: CHANTEL LAVOIE
O

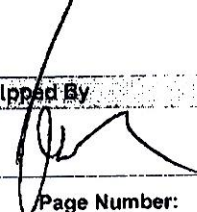
S DART AEROSPACE
H 1270 ABERDEEN STREET
I HAWKESBURY ON K6A 1K7
P CA
T Attn: CHANTEL LAVOIE
O Email: clavole@dartaero.com
Tel: (613) 632-5200

Purchase Order PO36858	Sales Order SO-019079	Incoterms	Payment Method COL
Carrier Account #	Ship Via FREIGHTCOM INC. -	Tracking Number	
Payment Terms NET 60	Account Status Active		

Item Number - Revision	Description	Quantity To Ship	UOM
CUSTOM -	SETS GREY POLYCARBONATE KIT Shipment Date: 7/6/2017 D3946 / D3947 SERIES HS Code: 8708.8.1000 - Country of Origin : CA	3 <u>3</u>	EA
	1 PC D3946-1P		
	1 PC D3947-4P ✓		
	1 PC D3947-3P		
	1 PC D3947-2P		
	1 PC D3947-1P		

SP 17-7-10

DAS
38
-89

Number of Containers	Gross Weight	Shipped By
		

DART AEROSPACE LTD		Work Order:	
Description: Panel, Lower RH		Part Number:	D3947-4
Inspection Dwg: D3947	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <i>N/A</i> "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by:	<i>DAS</i> <i>07</i> <i>9-89</i>	Date:	<i>17/07/19.</i>
---------------------	--	--------------	------------------

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.5	Min	<i>0.5"</i>	✓			
1.6	Min	<i>1.6"</i>	✓			
0.050	Min	<i>0.051"</i>	✓			
0.065	Min	<i>0.072"</i>	✓			
22.5	REF	<i>22.5"</i>	✓			
10.8	REF	<i>11.0"</i>	✓			

Measured by:	<i>DAS</i> <i>07</i> <i>9-89</i>	Date:	<i>17/07/19.</i>
Audited by:	<i>DAS</i> <i>38</i> <i>7-89</i>	Date:	<i>JUL 20 2017</i>
Prototype Approval:	<i>N/A</i>	Date:	<i>N/A</i>

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	<i>[Signature]</i>